

Work Order ID 73572

Tuesday, September 06, 2011 8:42:47 AM



Page 1

Item ID: D2805-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Stop

Start Date: 9/6/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/09/06

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2805	Rev B								

100

0.00



BAND SAW

B.A. 11/09/23

16 0

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Bar: 3.150" Long +0.010/-0.030"

110

0.00



HAAS CNC VERTICAL MACHINING #1

Re 11.9.23

16 0

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Machine as per Folio FA104 and Dwg D2805-2- Tumble and Deburr Identify as D2805-1

120

0.00



QC2- Inspect parts off machine FAI/FAIB

Re 11.9.23

16 0

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Setup Start



Revision ID:

Stop



Item Name: Stop

Start Date: 9/6/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				16	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				16	0		11/09/27
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				16X	0		11/09/27

16 0 11/09/27

16X 0 11/09/27

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Tuesday, September 06, 2011 8:42:47 AM



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Item ID: D2805-3	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Stop				
Start Date: 9/6/2011	Start Qty: 16.00		Cust Item ID:	
Required Date: 9/16/2011	Req'd Qty: 16.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
Packaging	Memo	0.00	SA	11/10/19		(16)			
Packaging									
170 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/10/19
MF
11-10-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 06, 2011 8:42:45 AM

Page 1

Work Order ID: 73572

Parent Item: D2805-3

Parent Item Name: Stop



Start Date: 9/6/2011

Required Date: 9/16/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP: A001.03.210New Issue0EC0

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.50 0		Purchased	No				f	14.6320		4.32			



6061-T6 Bar 1.50 x 1.50



Location	Loc Qty	Loc Code
MAT010	14.632	
107432	1.4	
✓116406	1.232	
118400	12	

4.32

B.A 11/09/23

could not pull stock

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	73572
Description: Stop		Part Number:	D2805-3
Inspection Dwg: D2805	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.974	+/-0.010	2.974	✓		RP - 2	
0.504	+/-0.010	.504	✓			
0.100 x 45°	+/-0.010 x 0.5°	.100	✓			
2.425	+/-0.010	2.430	✓			
2.654	+0.001/-0.000	2.655	✓			
0.608	+0.001/-0.000	.609	✓			
1.420	+/-0.001	1.419	✓			
Ø.191	+0.005/-0.000	.196	✓			
1.125	+/-0.010	1.124	✓			
0.250	+0.005/-0.000	.250	✓			
0.250	+/-0.010	.250	✓			
1.500	+/-0.010	1.500	✓			
0.875	+0.001/-0.000	.875	✓			
0.438	+0.001/-0.000	.438	✓			
1.000	+/-0.010	1.000	✓			

Measured by: RP / MK	Audited by: H.A	Prototype Approval:	N/A
Date: 11.9.23	Date: 11/09/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	

Dart Aerospace Ltd

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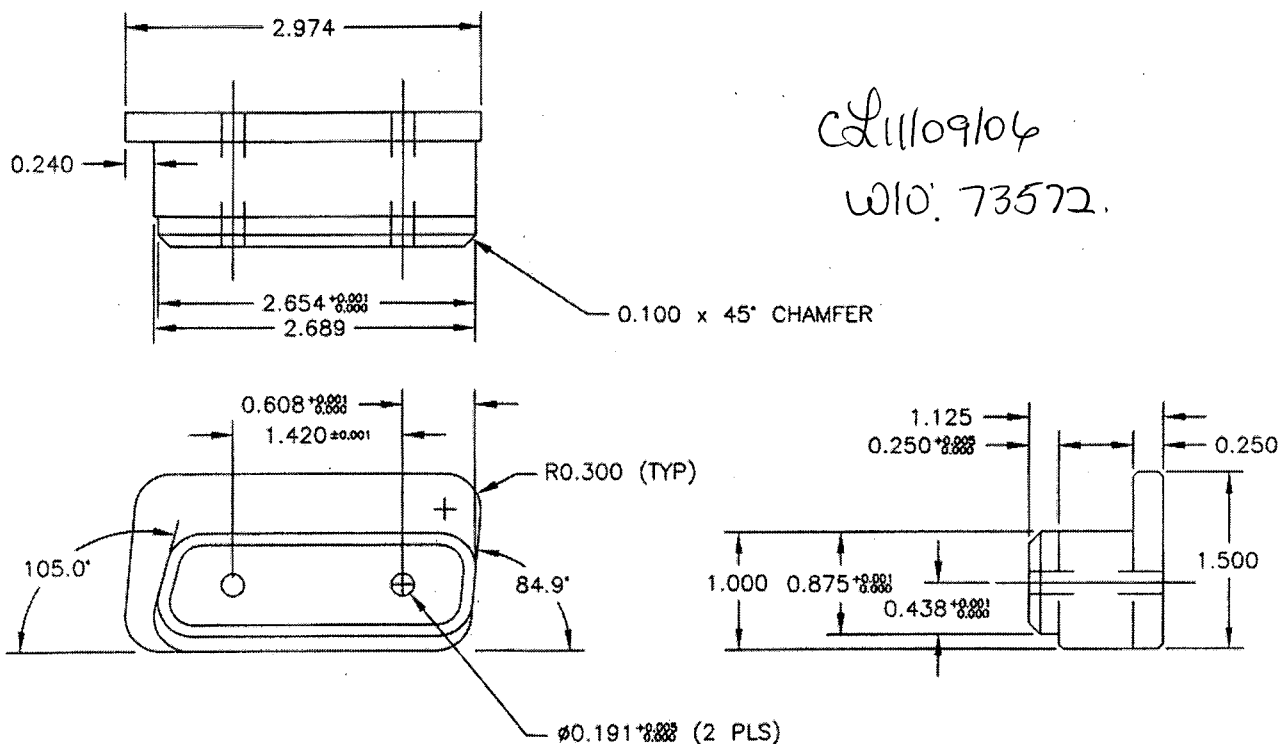
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DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2805	REV. B SHEET 1 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3
A	00.10.31	NEW ISSUE	
B	01.03.13	ADD -3/-4	

RELEASED
01.03.16 #



D2805-1 (SHOWN)
D2805-2 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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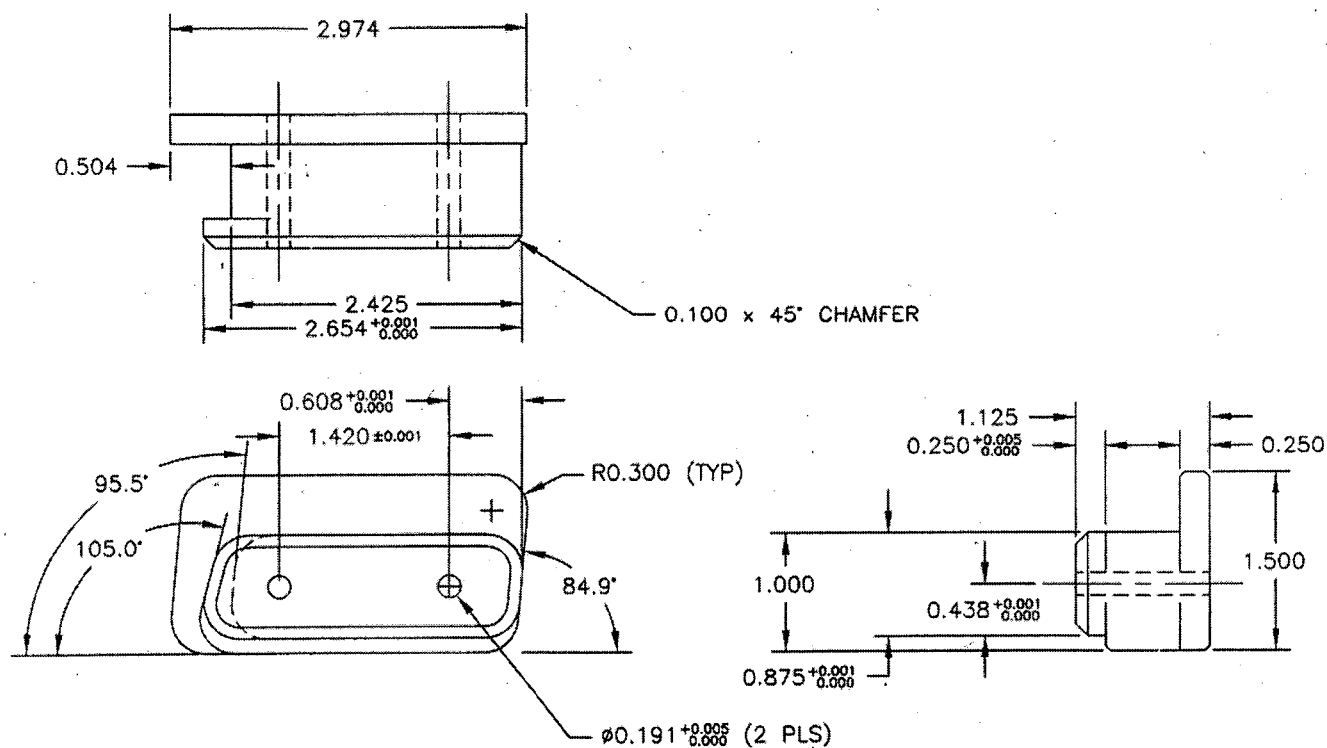
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DESIGN [Signature]	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2805	REV. B SHEET 2 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3

RELEASED
01.03.16



D2805-3 (SHOWN)
D2805-4 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
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